WHAT IS CLAIMED IS:
~~New Claims 1-4~~

1. A sack made of fabric consisting of monoaxially drawn, single-layer tapes of polymer, particularly polyolefine, preferably polypropylene, which fabric may be coated on one or both sides with thermoplastic material, particularly polyolefine, wherein the fabric is a seemless tubular fabric or a flat fabric combined to form a tube and at least one end of the sack is formed by folding the fabric ends to a particularly rectangular bottom surface, characterized in that at least one end of the sack, particularly a bottom surface, is bonded, via an intermediate layer (3b, 4b, 13) particularly made of thermoplastic, particularly polyolefine, preferably polypropylene material, by means of heat, to a cover sheet (3; 6) made of fabric consisting of monoaxially drawn tapes of polymer, in particular polyolefine and preferably polypropylene, and in that less than 30% of the material thickness of the fabric tapes of bottom surface and cover sheet include disoriented polymer molecules due to the heat, wherein in the rest of the material area the molecules are oriented.

2. A sack according to claim 1, characterized in that the fabric parts (4, 4', 5, 5') folded to form an end of the sack, particularly a bottom surface, do not or not substantially overlap each other, and a separate cover sheet (3) is provided to seal off the bottom.

3. A sack according to claim 1, characterized in that the end of the sack, particularly the bottom surface, and the cover sheet are formed by overlapping areas (6, 6', 7, 7') when folding the sack fabric.

4. A sack according to claim 1, characterized in that a separate layer (13) made of plastic material, particularly polyolefine, preferably polypropylene melt, is interposed as an intermediate layer between the end of the sack, particularly the bottom surface, and the cover sheet.

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5. A sack according to ~~any one of claims 1 to 3~~ claim 1, wherein in the case of tape fabric coated on one or both sides this coating (3b, 4b) serves as an intermediate layer between the end of the sack, in particular the bottom surface and the cover sheet.

6. A sack according to ~~any one of the preceding claims~~ claim 1, wherein an ethylene and vinyl acetate polymer is mixed with the coating (3b, 4b) of the tape fabric and/or the intermediate layer (13) made of thermoplastic material.

7. A sack according to ~~any one of the preceding claims~~ claim 1, wherein there is provided, on at least one side of one end surface formed by the fabric flaps (4, 4', 5, 5') in an area near, particularly within, the common part of the folding edge (21, 22) between a longitudinal (4, 5) and a narrow-side (4', 5') fabric flap, at least one adhesive point or adhesive area (20, 20') made of a cold-bonding agent, a hot-melt-type adhesive or a thermoplastic material, particularly polyolefine, having a lower melting point than the material of the fabric or the intermediate layer.

8. A sack according to ~~any one of the preceding claims~~ claim 1, wherein on at least one side of an end surface formed by fabric flaps (4, 4', 5, 5') at least one of the longitudinal fabric flaps (4, 5) has at least one opening (19, 19') in that area which, in its folded state, overlaps a narrow-side fabric flap (4', 5').

9. A sack according to ~~any one of the preceding claims~~ claim 1, wherein the longitudinal (4, 5) and narrow-side (4', 5') fabric flaps forming one end surface of the sack are at least partly welded together in those areas in which they overlap each other.

10. A sack according to ~~any one of the preceding claims~~ claim 1, wherein in the areas of the end surfaces in which the pockets are formed by folding all superimposed layers of fabric are bonded to each other by a welding point or a welding area.

11. A sack according to ~~any one of the claims 1 to 10~~ claim 1, wherein between the end of the sack, particularly the bottom surface, and the cover sheet there is provided at least one valve (2) through which the sack can be filled and which, when the sack is full, can be closed automatically by the pressure of the filling material.

12. A sack according to claim 11, wherein there is provided at least one opening (18, 18') in at least one longitudinal fabric flap (4, 5) involved in the formation of the end surface of the sack in the area between the inner edge (5'') of the narrow-side fabric flap (5') and the inner edge (2') of the valve (2) disposed between the narrow-side (5') and the longitudinal (4, 5) flaps.

13. Sack according to ~~any one of the claims 1 to 12~~ claim 1, wherein the tape fabric is perforated.

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New Claims 14 and 15:

14. A process for welding a cover sheet onto an end surface, in particular a bottom surface, of a sack particularly according to ~~any one of claims 1 to 11~~ claim 1, wherein the sack material consists of fabric made of monoaxially drawn tapes of polymer, particularly polyolefine, preferably polypropylene, particularly having a thickness of 20-80 μm, and the cover sheet consists of foil or fabric of monoaxially drawn tapes of polymer, in particular polyolefine, preferably polypropylene, characterized in that an intermediate layer made of molten polymer, particularly polyolefine, preferably polypropylene, preferably having a thickness of 5 - 60 μm, is introduced particularly at a temperature of 150 - 380°C, between the end surface and the cover sheet, as well as in that the end surface and the cover sheet are subsequently pressed together and that the end surface, the intermediate layer and the cover sheet are cooled to ambient temperature from the outsides of the end surface and the cover sheet, so that less than 30% of the material thickness of the fabric tapes of the bottom surface and the material thickness of the cover sheet have disoriented molecules because of the influence of heat, while in the remaining material region molecular orientation remains.

15. A process for welding a cover sheet onto an end surface, in particular a bottom surface, of a sack, particularly according to ~~any one of claims 1 to 11~~ claim 1, wherein the sack material consists of fabric made of monoaxially drawn tapes of polymer, in particular polyolefine, preferably polypropylene, in particular having a thickness of 20-80 μm, and the cover sheet consists of foil or fabric of monoaxially drawn tapes of polymer, in particular polyolefine, preferably polypropylene, wherein at least one fabric or the foil thereof is coated with a layer consisting of thermoplastic material, particularly having a thickness of 5 - 60 μm, facing towards the other fabric or the foil in the welding process, characterized by heating the coating or coatings to the point of plastification, in particular to a temperature of 150-380°C, from the inner side, subsequent pressing of end surface and cover sheet together and cooling of end surface, coating or coatings and cover sheet to ambient temperature from the outside of end surface and cover sheet, so

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that less than 30% of the material thickness of the tapes of fabric of the bottom surface or the material thickness of the cover sheet have disoriented molecules because of the influence of heat, molecule orientation remaining unchanged in the remaining material region.

16. A process according to claim 14 ~~or 15~~, wherein for welding a cover sheet onto an end surface, particularly a bottom surface, of a sack the cooling and pressing steps of the end or bottom surface and the cover sheet are effected simultaneously by means of at least one cooled pressing element, particularly a pair of rollers (17, 17).

17. A process according to claim 14, wherein for welding a cover sheet onto an end surface, particularly a bottom surface, of a sack molten plastic material, particularly polyolefine, preferably polypropylene, is introduced through a broad-slit or fiber-extrusion die (16).

18. A process according to claim 14 ~~or 15~~, wherein for welding a cover sheet onto an end surface, particularly a bottom surface, of a sack the end or bottom surface and the cover sheet are heated and pressed against each other by at least one heated roller or plate having a line or point-like surface profile.

19. A process according to claim 14 ~~or 15~~, wherein the welding of a cover sheet onto an end surface, particularly a bottom surface, of a sack is effected by friction welding.

20. A process according to ~~any one of claims 14 to 19~~ claim 14, wherein an ethylene and vinyl acetate polymer is mixed with the coating (3b, 4b) of the tape fabric and/or the intermediate layer (13) made of thermoplastic material.

21. A process according to ~~any one of claims 14 to 20~~ claim 14, wherein prior to the step of introducing molten polymer between the end surface and the cover sheet at least one opening (19, 19') is provided in at least one longitudinal fabric flap (4, 5) in that area which, in its folded state, overlaps a narrow-side fabric flap (4', 5').

22. A process according to ~~any one of claims 14 to 21~~ claim 14, wherein there is provided, particularly prior to folding the flaps (4, 4', 5, 5') to an end surface of the sack and at least on one side of an area close to, and in particular within, the common portion of the folding edge (21, 22) between a longitudinal (4, 5) and a narrow-side (4', 5') fabric flap, at least one adhesive point or adhesive area (20, 20') of a cold-bonding agent, hot-melt-type adhesive or a thermoplastic material, particularly polyolefine, having a lower melting point than the material of the fabric or of the intemediate layer, and wherein after folding the flaps in a further step by applying heat and/or pressure the adhesive material (20, 20') is bonded to the longitudinal (4, 5) as well as the narrow-side (4', 5') flaps.

23. A process according to ~~any one of claims 14 to 22~~, claim 14 wherein between the overlapping areas of the longitudinal (4, 5) and narrow-side (4', 5') fabric flaps of one end surface of the sack hot air is blown in and the flaps are pressed against each other, thereby bonding them together.

24. A process according to ~~any one of claims 14 to 23~~ claim 14, wherein the fabric flaps disposed longitudinally (4, 5) and on the narrow side (4', 5') and those forming a pocket by folding are welded with each other by pressing a heated pin or a heated plate from outside the end surface of the sack against them.

25. A process according to ~~any one of claims 14 to 24~~ claim 14, wherein prior to the step of introducing molten polymer between the end surface and the cover sheet at least one opening (18, 18') is provided in at least one longitudinal fabric flap (4, 5) involved in the formation of an end surface of the sack in an area which is defined by the inner edge

(5'') of the narrow-side fabric flap (5') and the inner edge (2') of a valve disposed between the narrow-side (5') and the longitudinal (4, 5) flaps.